

SMALL FAB

6237

KING

SHV

7-20



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW1205G00231-3G

Job Sheet 178537



Part No: RBW1205G00231-3G

Job Qty: 1 ea

Part Name: Main Rotor Damper Oil Filling Adapter



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 6/1/18

Job Tracking No:

Due Date: 7/9/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBW1205G00231-3G Rev 2B IPP Rev A 18.02.14m New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/9/18	7/9/18	0.00	0.00	Start Up Small Fab-4		MLL
100	Small Fab	1 pcs	7/9/18	7/9/18	0.25	0.25	Small Fab-9		MLL
110	QC	1 pcs	7/9/18	7/9/18	0.00	0.00	QC5		SB
130	Packaging	1 pcs	7/9/18	7/9/18	0.00	0.00	Packaging3-2		MLL
140	QC21-FG	1 Ea	7/9/18	7/9/18	0.00	0.00	QC21		MLL

Part Op 100 - Assemble as per DWG.
Descriptions: 130 - Identify and Stock

DAS
53
9-89

JUL 19 2018

GA 102

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91611A108	Spring Pin 2mmRND x 18mm	2 Ea (2 ea)	90-Start up Operation	5004183
AN815-6D	Union M Flare	1 Ea (1 ea)	90-Start up Operation	5083008
RBW1205G00231-3G-1	Body	1 Ea (1 ea)	90-Start up Operation	5011808
RBW1205G00231-3G-3	Tube	1 Ea (1 ea)	90-Start up Operation	5063289
RBW1205G00231-3G-5	Pressure Relief Plug (Modified B/O)	1 Ea (1 ea)	90-Start up Operation	5089897
RBW1205G00231-3G-7	Washer	1 Ea (1 ea)	90-Start up Operation	5075932
V75-010	O-ring	2 Ea (2 ea)	90-Start up Operation	5038451
V75-011	Viton 75D Brown O-ring	1 Ea (1 ea)	90-Start up Operation	5038453
V75-013	Viton 75D O-ring	1 Ea (1 ea)	90-Start up Operation	5038452

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	91611A108	2	192	0
	AN815-6D	1	28	0
	RBW1205G00231-3G-1	1	0	0
	RBW1205G00231-3G-3	1	17	0
	RBW1205G00231-3G-5	1	0	0
	RBW1205G00231-3G-7	1	3	0
	V75-010	2	36	0
	V75-011	1	43	0
	V75-013	1	43	0

Part Specifications

Specifications could not be found.



Container No: S093791



Part: RBW1205G00231-3G

Job No: 178537

Serial No/Batch: S093791

Revision: 2B

Inspector:

Exp Date:

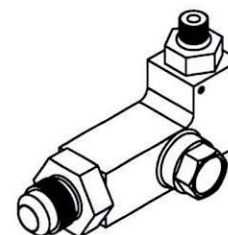
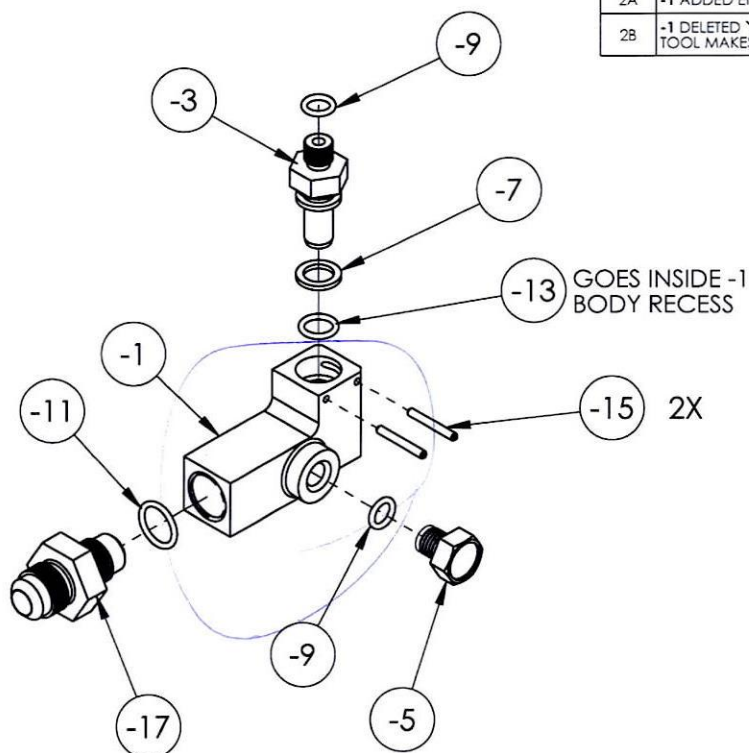
Instructions:

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www.dartaerospace.com

Date: 07/19/18

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED PART -17, -1 REMOVED 7/16-20 THREADED NIPPLE, MOVED RELIEF VALVE .100.	2/24/2011	JAG	
2	-1 CH'D TO USE PORTING TOOL 2 PLACES.	12/20/2011	JAG	
2A	-1 ADDED ENGRAVE NOTE PER S.E.	3/28/2012	RJC	SE
2B	-1 DELETED ∇ $\varnothing$.37 X 90°, NEAR SIDE CALLOUT FROM 5/16-24 ∇ .50 BECAUSE 5/16-24 PORTING TOOL MAKES THIS FEATURE	1/21/2014	DPD	GE



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 178531

20180622

FUNCTION: PART OF HELICOPTER SERVICING KIT T/N 3G1205G00131.
USED IN CONJUNCTION WITH A MANUAL HYDRAULIC OIL PUMP TO
RESTORE THE HYDRAULIC OIL LEVEL INTO THE M/R DAMPER

ORIGINAL No. REF
RBW1205G00231-3G = 3G1205G00231
RBW1205G00213-3G-1 = 3G1205G00651
RBW1205G00231-3G-3 = 3G1205G00551
DO NOT USE, FOR REGERENCE ONLY

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BODY	6061	1-1/8 X 1-3/8 X 2-3/16	2
			-3	1	TUBE	6061	$\varnothing$ 3/4 X 1-1/2	3
			-5	1	AN PRESSURE RELIEF PLUG	ALUMINUM	AIRCRAFT SPRUCE #AN814-2D (MODIFIED)	4
			-7	1	WASHER	NYLON	$\varnothing$ 1/2 X 3/16	5
		B/O	-9	2	O-RING	VITON	ID 1/4 X 1/16 WIDTH #V75-010	1
		B/O	-11	1	O-RING	VITON	ID 7/16 X 1/16 WIDTH #V75-013	1
		B/O	-13	1	O-RING	VITON	ID 5/16 X 1/16 WIDTH #V75-011	1
		B/O	-15	2	ROLL PIN	STEEL	$\varnothing$ 2mm X 18mm MCMaster-CARR #91611A108	1
		B/O	-17	1	FITTING	ALUMINUM	MS24392D6	1



RED BARN MACHINE

TITLE		
MAIN ROTOR DAMPER OIL ADAPTER		
DWG NO.		REV
RBW1205G00231-3G		2B
MATL		DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weil</i>
.XXX $\pm$.005 FRACTIONS $\pm$ 1/32		HEAT TREAT
.XX $\pm$.01 ANGLES $\pm$ 5°		FINISH
.X $\pm$.1		SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		AGUSTA
SCALE	1:2	DATE 2/23/2011
		SHEET 1 OF 5

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					